

Work Order ID 106969

September-12-13 8:02:04 AM

\*106969\*

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Item ID: D4840-041 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Upper Cutter Assembly  
 Start Date: 9/12/13 Start Qty: 1.00 \*1\* Cust Item ID:  
 Required Date: 9/24/13 Req'd Qty: 1.00 \*1\* Customer:  
 Reference:

Approvals: Process Plan: W Date: Tooling: Date: Run Start \*NR1\*  
 QC: Date: SPC (Y/N): Date: Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4840	REV A								
110	Pick Kit	0.00							
*110*									
Packaging	Memo	0.00							
Packaging									
120		0.00							
*120*									
Small Fab	Memo	0.00							
Small Fab	Assemble as per dwg and apply loctite 598 on all faying surfaces.								
	A/R LOCTITE 598: <u>125306</u>								
130	QC5- Inspect part completeness to step on W/O	0.00							
*130*									
QC	Memo	0.00							
Quality Control									

1 WHL 13.11.14  
 1 WHL 13.11.14  
 Pto →  
 ① WHL 13.11.15

NCR: Yes / No

## WORK ORDER NON-CONFORMANCE / UPDATE

DQA: 13/12/05 Date: 13/12/05QA Closed: 13/11/22 Date: 13/11/22

Work Order: <u>156969</u> Part No. <u>D4840-041</u> NCR No. <u>131-32602</u>	<b>DISPOSITION</b> Rework <input checked="" type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b> <table style="width:100%; font-size: small;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input checked="" type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input checked="" type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input checked="" type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data <input type="checkbox"/>	13/11/15	120	X/	Found when closing w/o's that the B & R for the D4823-1 was not correct when investigation was done D4842-1 was used. Re. employee did not use correct Part & was inspected incorrectly.	DAS 16 9-89  13/11/15 052042	Removed D4842-1 and clean up all inactive 598 scrap 194 Bots & nuts.	mhw 13.11.18	13.11.18	DAS 16 9-89  13/11/15 052042
Equip/Tooling <input type="checkbox"/>						Reinstall the correct D4823-1 B 105011	mhw 13.11.18		
Operator <input checked="" type="checkbox"/>						New MS27039-0819 M125654			
Material <input type="checkbox"/>						MS 21042468 M122814			
Setup <input type="checkbox"/>						MS 27039			
Other <input type="checkbox"/>						was 1149FW832P			
Process <input type="checkbox"/>						M 123900			
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

## FAULT CATEGORY

Landing Gear	General	Other
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input checked="" type="checkbox"/> Hardware
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete
<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Misabeled
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input checked="" type="checkbox"/> Other

AND inspected incorrectly.

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 Required Date: 9/24/13 Req'd Qty: 1.00 \*1\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Identify as per dwg & Stock Location: _____	0.00							
*140*									
Packaging	Memo	0.00				①		②	13-11-15
Packaging									
150	QC21- Final Inspection - Work Order Release	0.00							
*150*									
QC	Memo	0.00							
Quality Control									

PP 109/96

JA/Rm 13/11/18

13-11-18

# Picklist Print

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12.

Work Order ID: 106969  
Parent Item: D4840-041  
Parent Item Name: Upper Cutter Assembly

Start Date: 9/12/13  
Start Qty: 1.00

Required Date: 9/24/13  
Required Qty: 1.00

Comments: IPP REV:A 13.04.29 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
+ D4823-1 ✓ Upper Cutter Deflector		Manufactured	No				Each	0.0000	B# 105011	1	W/W	13.11.14	
D4824-1 ✓ Upper Cutter Mount		Manufactured	No				Each	0.0000	B# 104929	1	W/W	13.11.14	
+ D4838-2 - Upper Cutter Body, RH		Manufactured	No				Each	0.0000	B# 104997	1	W/W	13.11.14	
+ D4838-1 ✓ Upper Cutter Body, LH		Manufactured	No				Each	0.0000	B# 105128	1	W/W	13.11.14	
+ D4839-1 ✓ Blade		Manufactured	No				Each	2.0000	B# 100706	2	W/W	13.11.14	

Location				Loc Qty	Loc Code	
prelim				2		
100706				2		
MS27039-08-19	Purchased	No		Each	2,162.0000	14 W/W 13.11.07
Screw						

Location	Loc Qty	Loc Code
ST307	89	
123525	89	
ST308	40	
m126474	40	
ST309	833	
125654	833	
st510	1200	
124309	1200	

# Picklist Print

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Work Order ID: 106969

Parent Item: D4840-041

Parent Item Name: Upper Cutter Assembly

Start Date: 9/12/13

Required Date: 9/24/13

Start Qty: 1.00

Required Qty: 1.00

NAS1149FN832P

Purchased

No

Each

14,908.000

28

Washer

*m/m* 13.11.07

Location

Loc Qty

Loc Code

ST294

4932

123522

398

123900

4534

ST510a

9976

125268

9976

MS21042L08

Purchased

No

Each

3,002.0000

14

Nut

*m/m* 13.11.07

Location

Loc Qty

Loc Code

ST315

1002

122141

3

122452

9

122814

500

123900

490

ST505

2000

125445

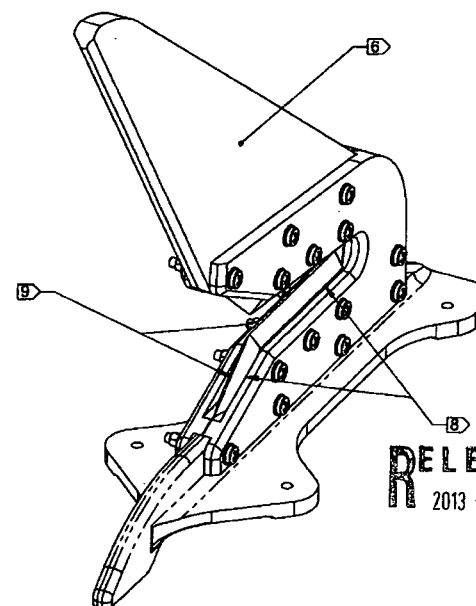
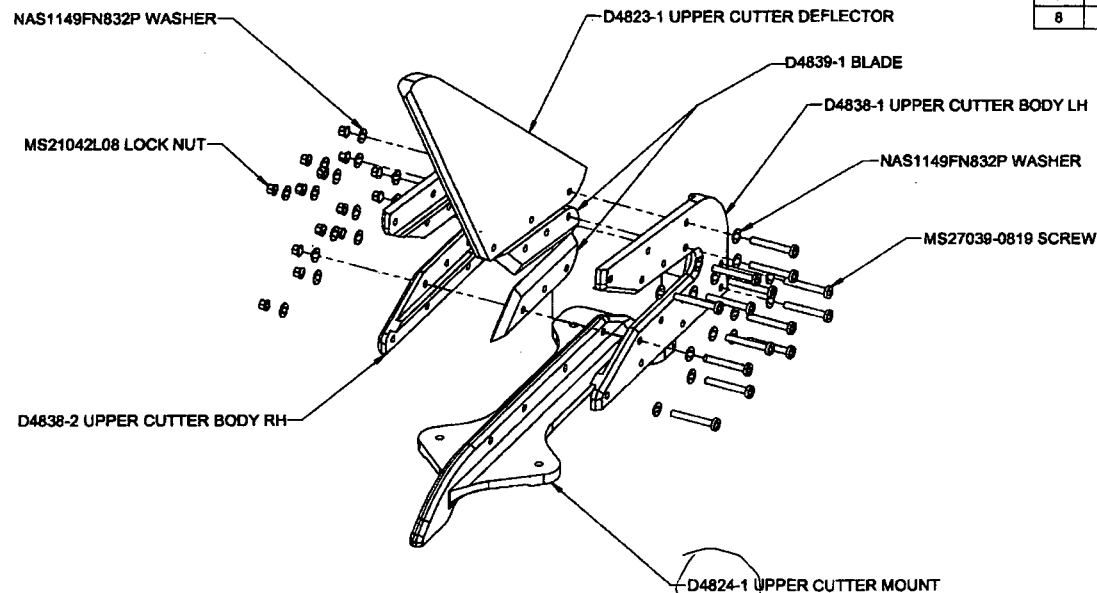
2000

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Shop Packet Print

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ITEM	QTY -041	P/N	DESCRIPTION
1	1	D4823-1	UPPER CUTTER DEFLECTOR
2	1	D4824-1	UPPER CUTTER MOUNT
3	1	D4838-1	UPPER CUTTER BODY LH
4	1	D4838-2	UPPER CUTTER BODY RH
5	2	D4839-1	BLADE
6	28	NAS1149FN832P	WASHER (AN980C10)
7	14	MS27039-0819	SCREW
8	14	MS21042L08	LOCKNUT



**RELEASED**  
2013-07-12  
JMP

**D4840-041 UPPER CUTTER ASSEMBLY**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: N/A
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4840-041", AGUSTA WESTLAND KIT NUMBER "TBD", REVISION, BATCH NUMBER AND MANUFACTURE DATE, USING AN X-TENSION STAMP, AS PER QSI 044 METHOD 8.2
- 7) WEIGHT: 3.77 LBS (1.63 KGS).
- 8) APPLY RTV SEALANT TO ALL FAYING SURFACES UPON ASSEMBLY
- 9) CUTTING EDGE INTENDED TO BE SHARP. DO NOT BREAK SHARP EDGE.

A NEW RELEASE		DB	13.05.23
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	A.P.	DRAWING NO.	REV. A
MFG. APPR.	1/2	D4840	SHEET 1 OF 1
APPROVED	1/2	TITLE	SCALE
DE APPR.	1/2	UPPER CUTTER ASSY	NTS
DATE	13.05.23	<small>COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE REPRODUCED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	